

# Work Order ID 61184

August 11, 2010 7:42:58 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 8/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/8/11 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

HJ dr BG 10-8-30

8/10/08/30

B61184

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Start Date: 8/11/10 Start Qty: 1.00

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110



Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)  
\*\*\*ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150\*\*\*

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper positioning.

9- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

10- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

AUM 10-08-13

10-8-16

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.297"

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐

13-Grind welds flush as per Dwg D2750

DP

10-8-16

M114877

BE 10-8-17

BE 10-8-17

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/08/17

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/08/17

Memo

0.00

NO

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

10-8-17



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ZE 10-8-18

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291batch: M115114exp. date: 11-1-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod

batch:

M114877BE 10-8-20

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 10-8-20

10-Grind welds flush as per Dwg D2750

BE 10-8-23

DP 10-8-18

W/O:		WORK ORDER CHANGES					
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Start Date: 8/11/10 Start Qty: 1.00

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Required Date: 8/20/10 Req'd Qty: 1.00

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

BE 10-8-23

12-Debur holes

BE 10-8-23

170

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/02/24



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

S 10/02/24



QC

Memo

0.00

Quality Control

(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No · DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BR 10-8-24

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:30pm

M 10/08/25

1 0

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

M 10 08 26 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	HandFinishing	0.00				<u>ml</u>	<u>10</u>	<u>08</u>	<u>26</u> ①
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
230 	HandFinishing	0.00				<u>ml</u>	<u>10</u>	<u>08</u>	<u>26</u> ①
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	<del>2-Spray inside of tube with "LPS-3" batch: <u>N/A</u></del>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>115114</u> EXP DATE: <u>11/01</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>114184</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		S 10/08/26		(xi)			
250  Packaging Packaging	Pick Kit  Memo	0.00  0.00							
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo *****ensure antiseize is on AN8C21A bolts*****	0.00  0.00		S 10/08/30		(xi)			

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Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
	Package as per PPP D350-636-011								
280		0.00							
QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/08/31  
CZ1018131

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH




Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07-13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec  
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verified by: EC IPP Rev: P 10.06.22  
 revise seq110 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3  O-Ring, 205 Skidtube		Manufactured	No			230	Each	379.0000	8	8			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FP</div> <div>379</div> <div></div> </div>													
<div> <div>55546</div> <div>19</div> <div></div> </div>													
<div> <div>58191</div> <div>12</div> <div></div> </div>													
<div> <div>59358</div> <div>348</div> <div></div> </div>													
D2744  Cap		Manufactured	No			110	Each	35.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>35</div> <div></div> </div>													
<div> <div>59198</div> <div>35</div> <div></div> </div>													
D2600-3-BENT  Extrusion Bent		Manufactured	No			110	Each	16.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>16</div> <div></div> </div>													
<div> <div>59410</div> <div>16</div> <div></div> </div>													

MM 10-08-26

BE 10-08-17

AWM 10-08-13 \*

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 299.0000 8 8  
Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	299	
50281	10	
57953	2	
59111	287	

D2739 Manufactured No 160 Each 0.0000 1 1  
350 I Beam

B61256

①

8 BE 10-8-19  
DP 10-8-18

D3490-3 Manufactured No 160 Each 54.0000 4 4  
Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	54	
59229	14	
60294	40	

D3490-1 Manufactured No 160 Each 19.0000 4 4  
Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	19	
59424	19	

B61217 4 BE 10-8-19

ALS4-1032-225 Purchased No 220 Each 5,945.000 38 38  
Insert

Location	Loc Qty	Loc Code
PK011	5945	
110768	5945	

ML 10-08-26

August 11, 2010 7:42:57 AM

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Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230

Each

93.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP013

93

59114

24

59420

69

D3793-3

Manufactured No

230

Each

13.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

12

59631

12

FP19

1

57947

1

AN8C35A

Purchased No

230

Each

53.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP

1

110847

1

ST346

52

114442

27

115188

25

D3793-1

Manufactured No

230

Each

15.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

15

59151

2

59630

13

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 4

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Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

18.0000

1

1



Blade Fitting Assembly, LH

Location

Loc Qty

Loc Code

FP

11

53915

11

FP007

7

56052

7

D3794-3

Manufactured No

230

Each

24.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP10

12

60826

12

FP18

12

56066

11

59153

1

AN6C44A

Purchased No

230

Each

177.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

175

111649

2

114653

1

114784

47

114941

75

115030

50

mm 10.08.26

mm 10.08.26

mm 10.08.26

B# 60826

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

56.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST303

56

113845

7

114934

49

D3536-25

Manufactured

No

230

Each

29.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP12

29

58820

5

59625

24

D3631-1

Manufactured

No

230

Each

571.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST072

297

60755

297

ST076

274

52693

206

54388

68

D3791-1

Manufactured

No

230

Each

20.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP17

20

58573

11

59626

9

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MM 10-08-26

MM 10-08-26

MM 10-08-26

MM 10-08-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 11, 2010 7:42:58 AM

Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No 230 Each 29.0000 38 38



washer

B# 115000

Location	Loc Qty	Loc Code
ST245	29	
107534	29	

*ml 10-08-26*

D2745 Manufactured No 230 Each 169.0000 8 8



Bushing

Location	Loc Qty	Loc Code
ST023	169	
52311	5	
59112	164	

*ml 10-08-26*

AN3C5A Purchased No 230 Each 1,464.000 34 34



Bolt

Location	Loc Qty	Loc Code
ST350	1454	
114330	11	
<u>115015</u>	743	
115108	300	
115316	300	
115371	100	
ST351	10	
113121	10	

*ml 10-08-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

August 11, 2010 7:42:58 AM

Work Order ID: 61184



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

230 Each 55.0000 3 3



Wearpad

B# 60491

Location	Loc Qty	Loc Code
FP	1	
55465	1	
FP17	54	
57713	3	
59593	3	
60192	48	

*M/ 10.08.26*

AN960C816L Purchased No

230 Each 21.0000 1 1



WASHER

Location	Loc Qty	Loc Code
ST348	21	
110584	18	
111424	3	

*M/ 10.08.26*

D3492-043 Manufactured No

230 Each 51.0000 8 8



Plug Assembly

B# 61207

Location	Loc Qty	Loc Code
FP	2	
54682	2	
FP013	49	
59117	1	
59190	4	
59421	14	
60712	30	

*M/ 10-08-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 425.0000 4 4



BOLT

Location Loc Qty Loc Code

ST351 425

~~111982~~ 425

230 Each 67.0000 8 8

Location Loc Qty Loc Code

FP 67

~~114451~~ 51

114496 16

230 Each 24.0000 1 1

D3535-25 Manufactured No 230 Each 24.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP18 24

~~59623~~ 24

230 Each 19.0000 1 1

D3794-1 Manufactured No 230 Each 19.0000 1 1



Gasket

Location Loc Qty Loc Code

FP010 19

57942 18

~~59627~~ 1

*ml 10.08.26*

*ml 10.08.26*

*ml 10.08.26*

*ml 10.08.26*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 726.0000 4 4  
  
 NUT

Location Loc Qty Loc Code

ST301 726  
 112314 726

D3493-1 Manufactured No 260 Each 48.0000 2 2  
  
 Washer

Location Loc Qty Loc Code

ST065 48  
 59127 18  
 60873 30

MS21083C8 Purchased No 260 Each 56.0000 1 2  
  
 NUT

Location Loc Qty Loc Code

ST303 56  
 113845 7  
 114934 49

AN8C21A Purchased No 260 Each 57.0000 2 2  
  
 BOLT

Location Loc Qty Loc Code

ST345 57  
 113558 17  
 114653 40

*M/10 08 26*

*[Signature]*

*59127*

*[Signature]*

*M/114934*

*[Signature]*

*M/113558*

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 10

August 11, 2010 7:42:58 AM

Work Order ID: 61184

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

*AS* ~~AN960C816L~~ *NA071490832R*  
WASHER

Purchased No 260 Each 21.0000 1 2

*NA114910* *lu*

Location	Loc Qty	Loc Code
ST348	21	
110584	18	
111424	3	

D3672-1 Manufactured No

230 Each 1,011.000 4 4

Phenolic Washer

Location	Loc Qty	Loc Code
ST077	993	
51674	5	
52505	988	
ST117	18	
34470	18	

*ml* *10.08.26*

D2741 Manufactured No

260 Each 21.0000 1 1

Blade, 350 Skidtube

Location	Loc Qty	Loc Code
ST466	21	
55905	1	
57949	20	

*57949*  
*2* ✓

D3532-1 Manufactured No

260 Each 31.0000 2 2

Spacer

Location	Loc Qty	Loc Code
ST068	31	
59426	9	
60510	22	

*60510*

*lu* *10/8/20* *(C)*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 61184



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 1.00

Required Qty: 1.00

D3672-13

Purchased

No

260

Each

842.0000

2

2

✓



Phenolic Washer



*P. 8/13/10*

Location

Loc Qty

Loc Code

ST077

842

54363

842

54363

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

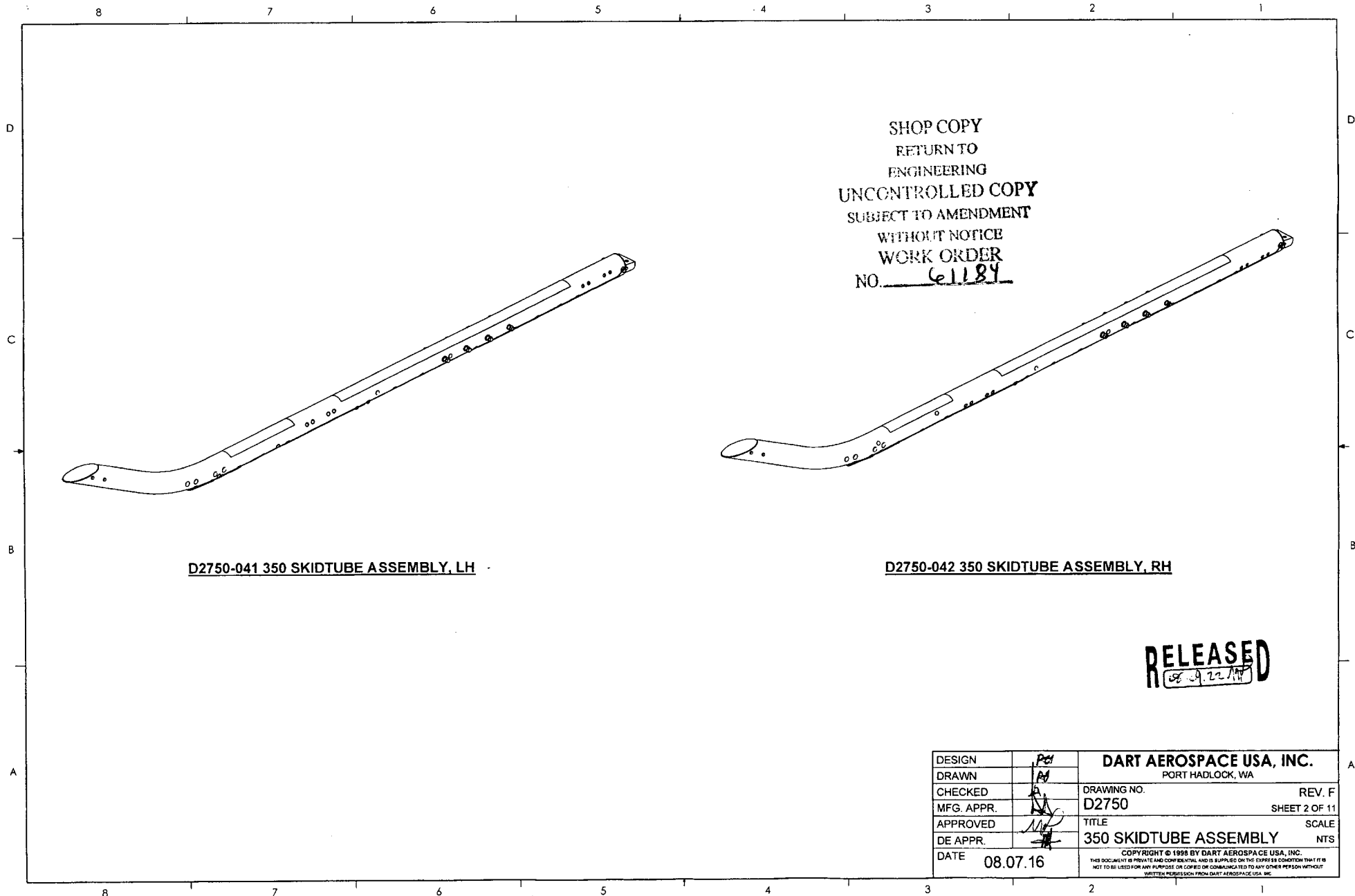
**NOTE:** Date & initial all entries

A

1) MATERIAL: MAKE D2750-11-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).  
2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS  
8) WELD PER DART QSI 004  
9) INSTALL AL54-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\varnothing 0.297$ ) FOR WEARSHOE INSERTS  
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI  
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.  
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL  $\triangle$   
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL  $\triangle$

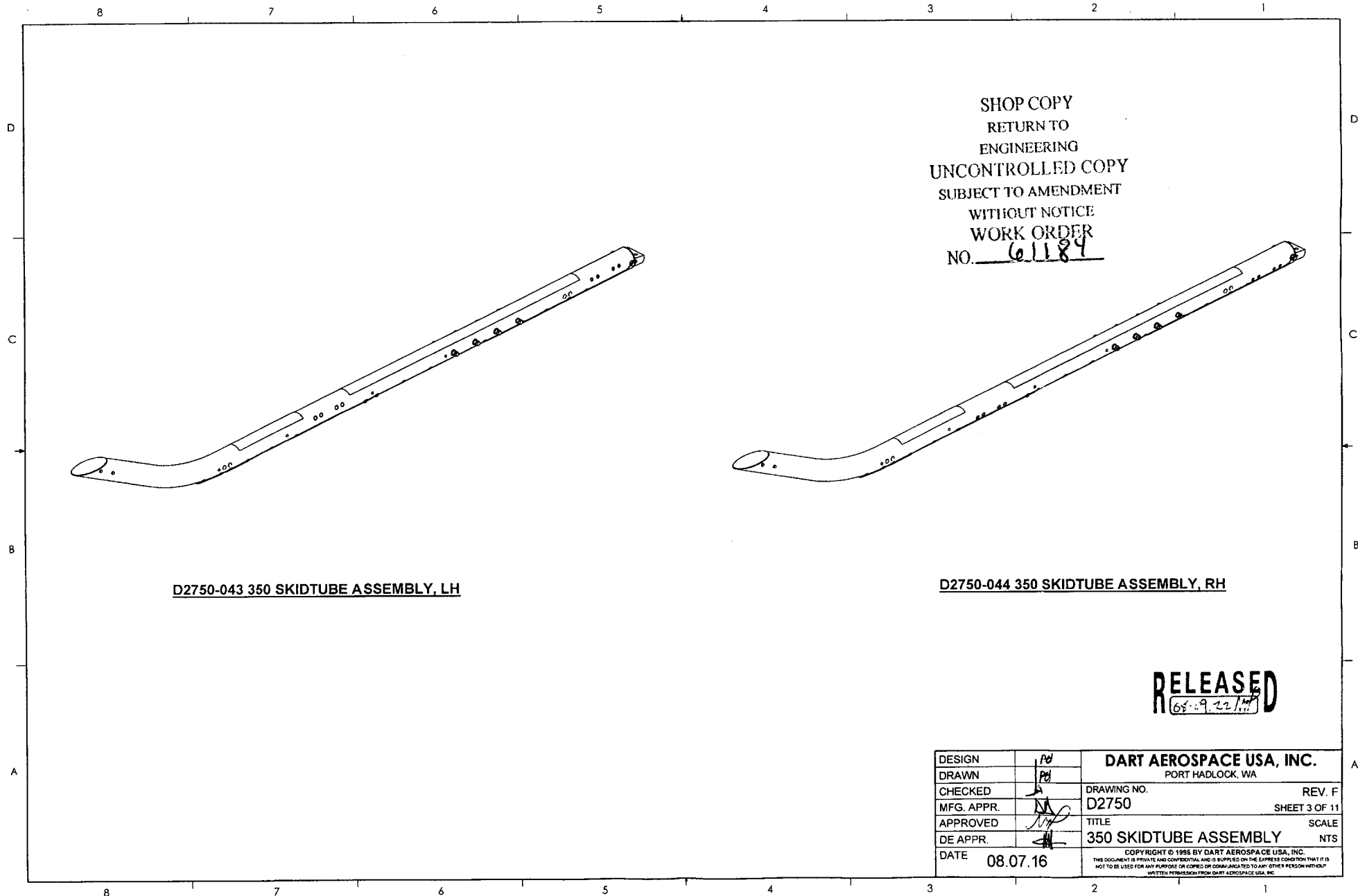
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68-029-22 MP

F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFD SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3; REMOVE QTY (10) NAS1515H8; REMOVE D2741; QTY (2) AN950C816; REMOVE QTY (2) MS21093C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	08.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	08.09.01
A	NEW ISSUE	DS	08.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PD</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>RD</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>MS</i>	D2750	SHEET 1 OF 1
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1993 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT TO BE USED FOR ANY PURPOSE OR TO BE COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE USA, INC.	



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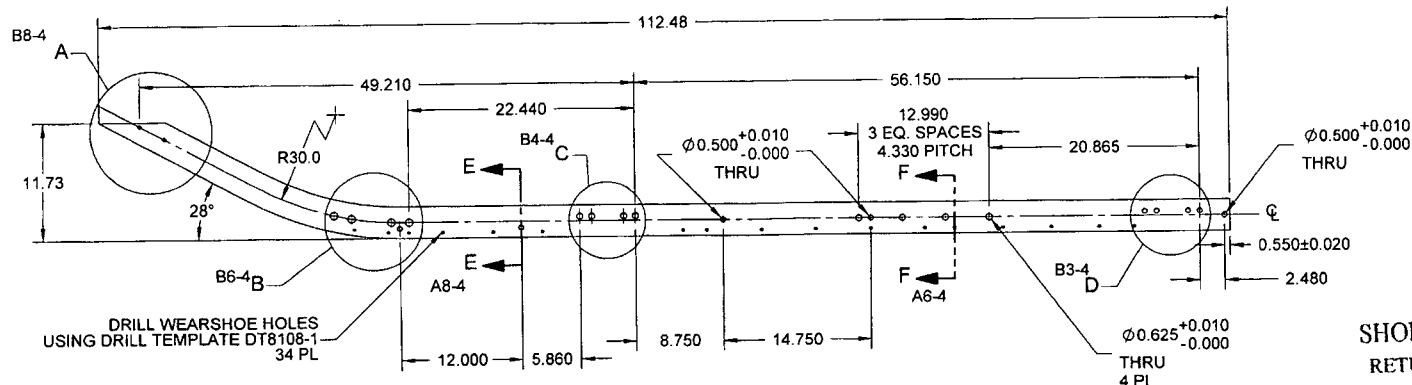
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 WORK ORDER  
 NO. 61184

D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

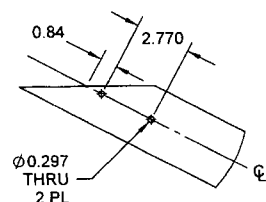
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 08-09-22/111

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CHECKED	PA	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	PA	SHEET 3 OF 11	
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1996 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

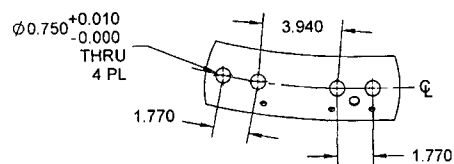


# **D2750-1 LH SKIDTUBE**

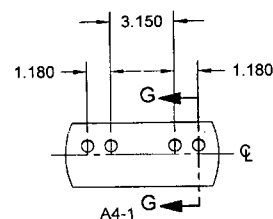
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WITHOUT NOTICE  
WORK ORDER  
NO. 61184



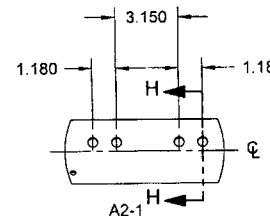
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SCALE 2X



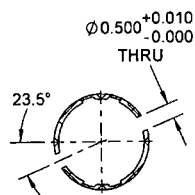
**DETAIL B**  
SCALE 2X



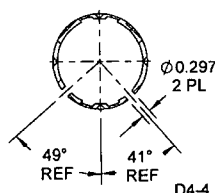
**DETAIL C**  
SCALE 2X



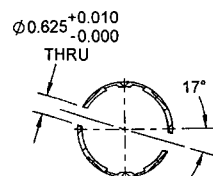
**DETAIL D**  
SCALE 2X



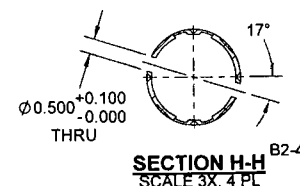
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



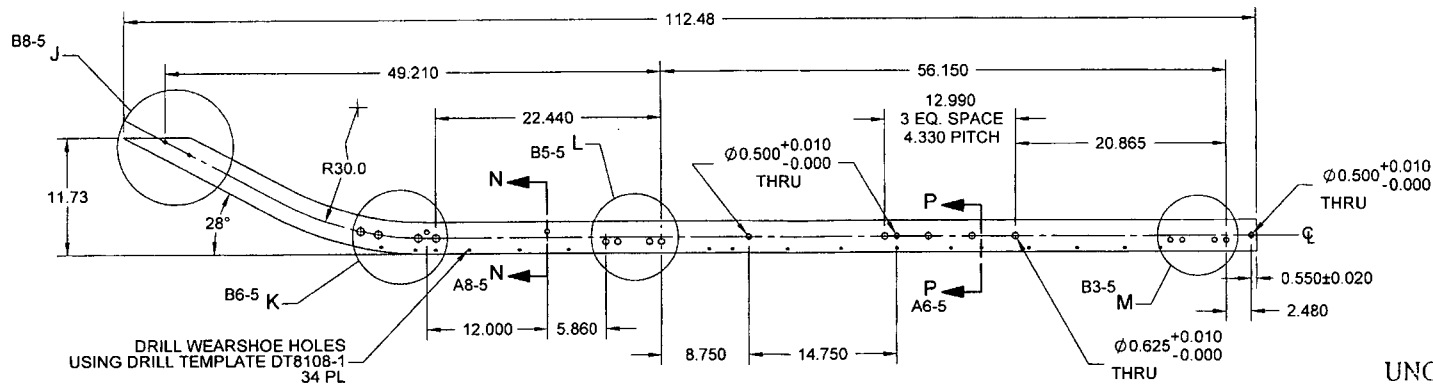
**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

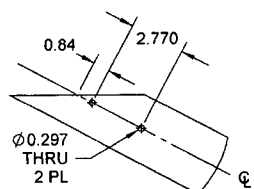
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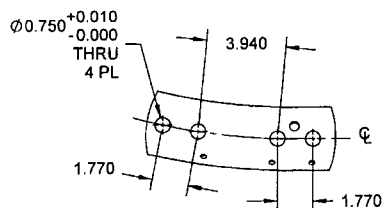


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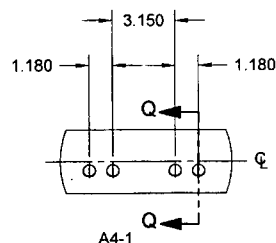
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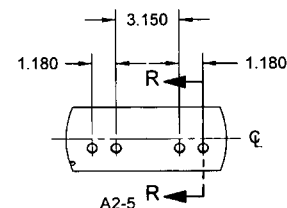
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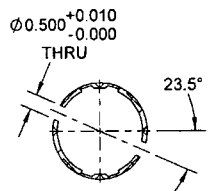
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SCALE 2X



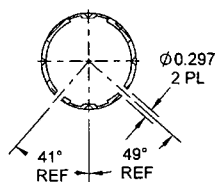
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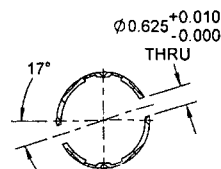
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SCALE 2X



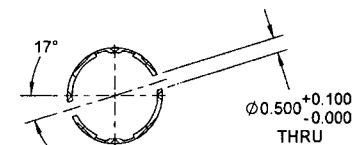
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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8

7

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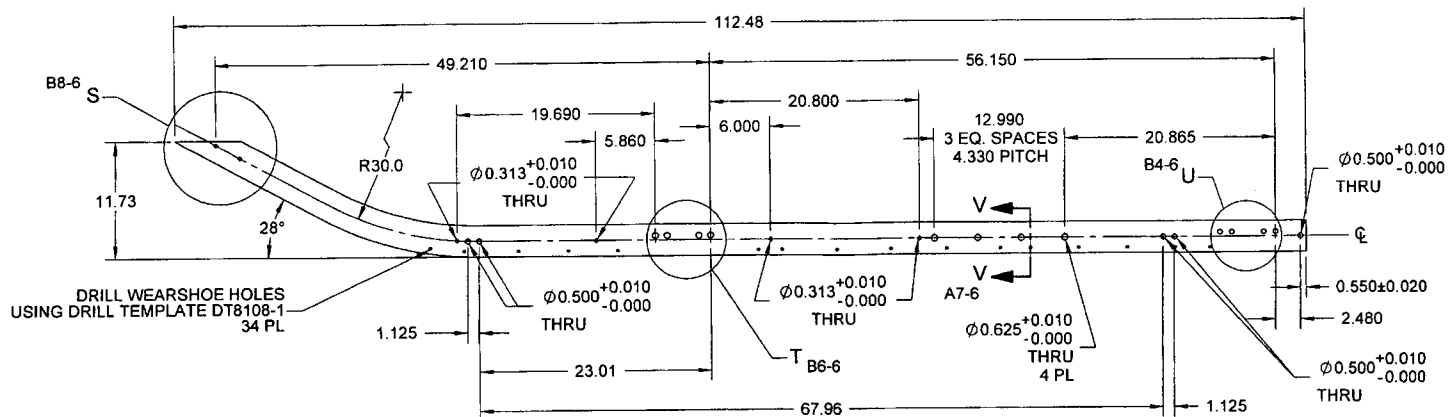
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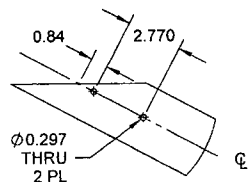
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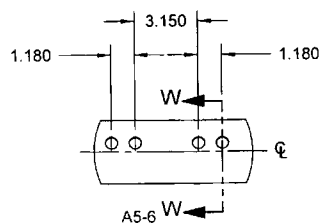


### D2750-3 LH SKIDTUBE

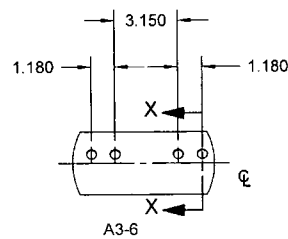
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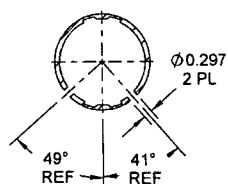
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D8-6  
SCALE 2X



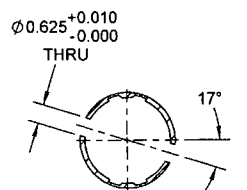
**DETAIL T**  
C5-6  
SCALE 2X



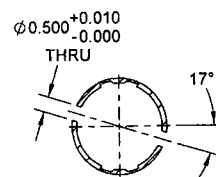
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL

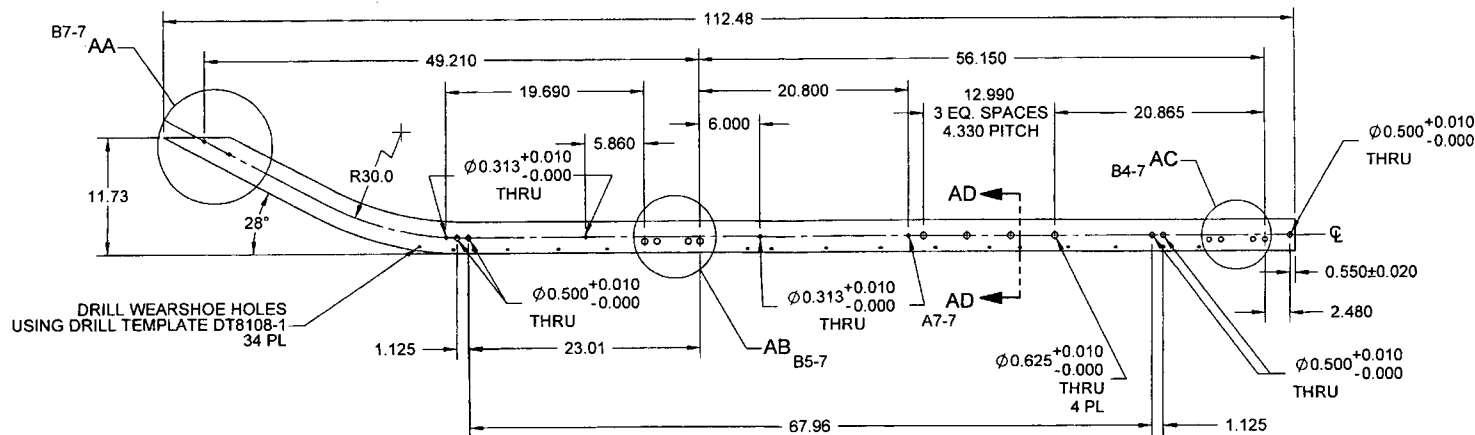


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SCALE 3X, 4 PL

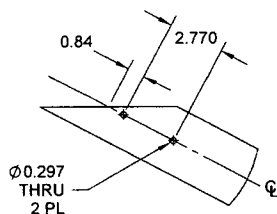
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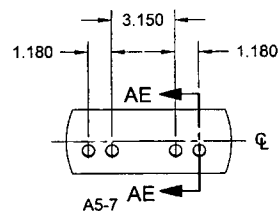




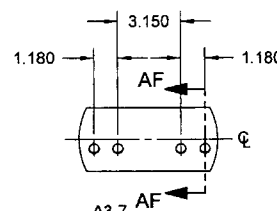
**D2750-4 RH SKIDTUBE**



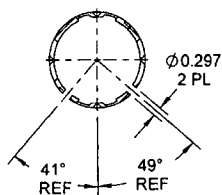
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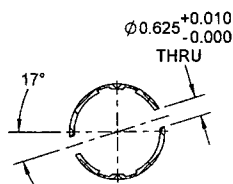
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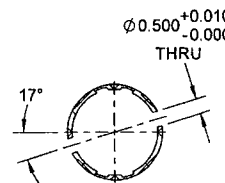
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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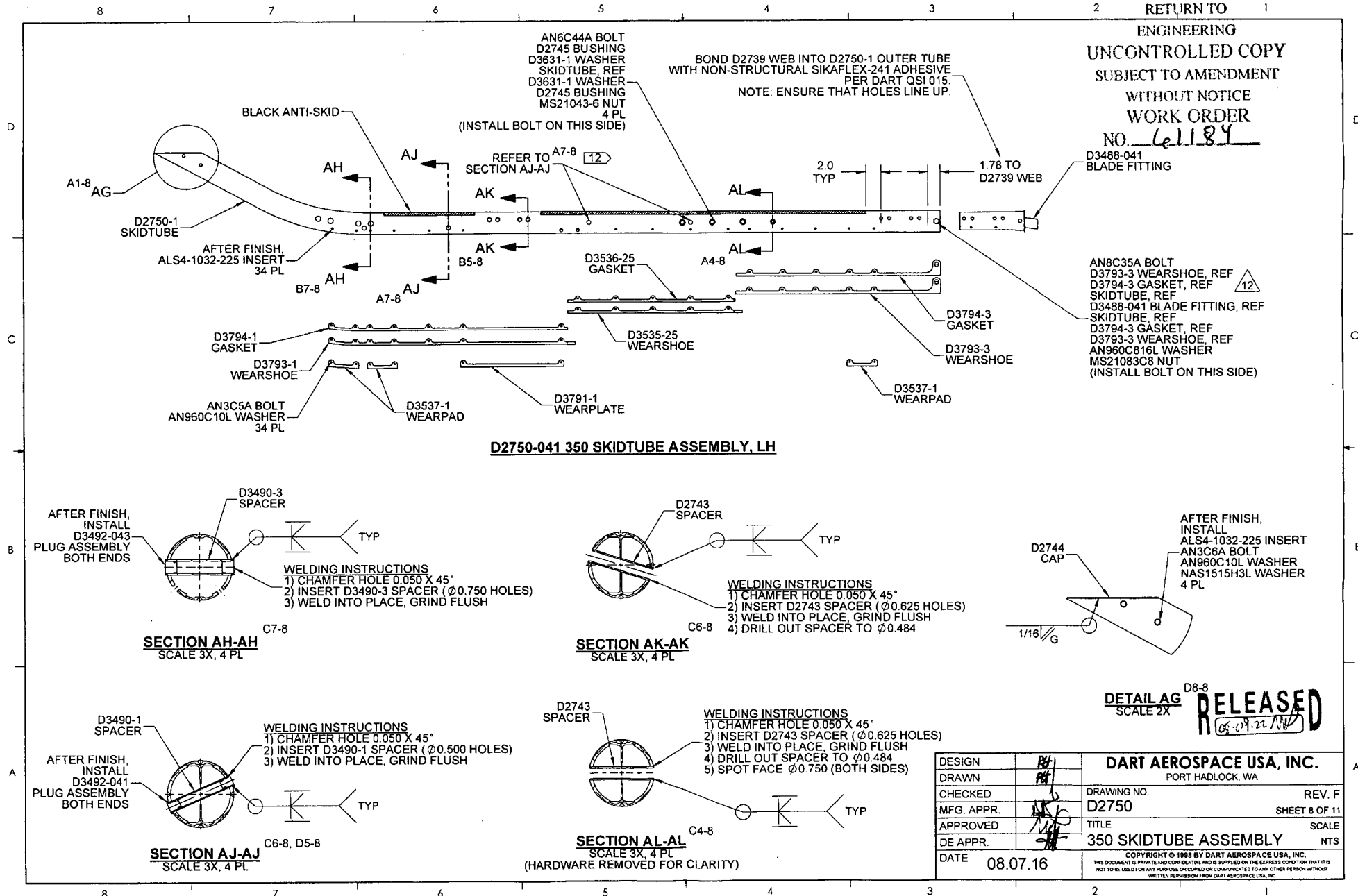
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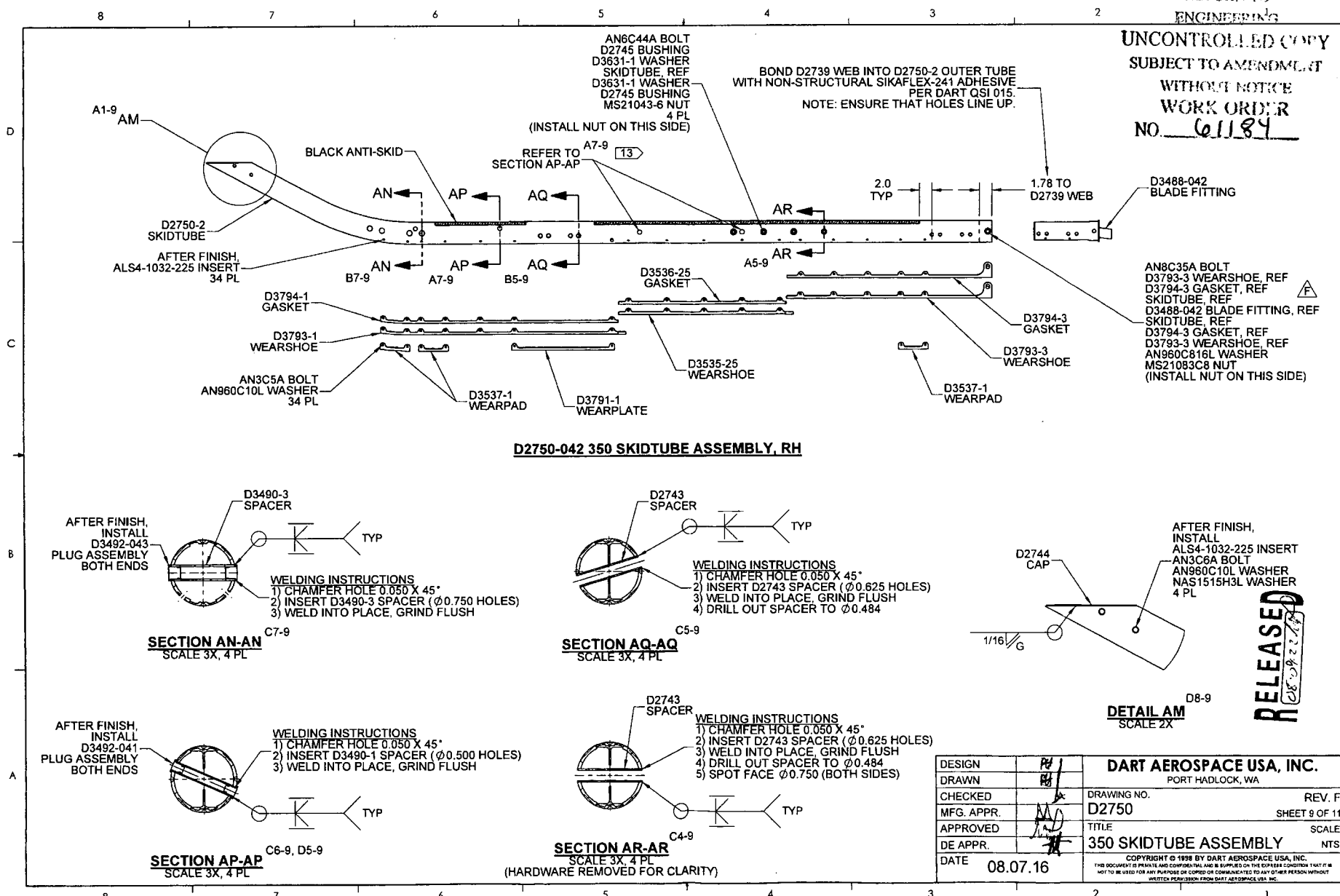
NO. 61184D3488-041  
BLADE FITTING

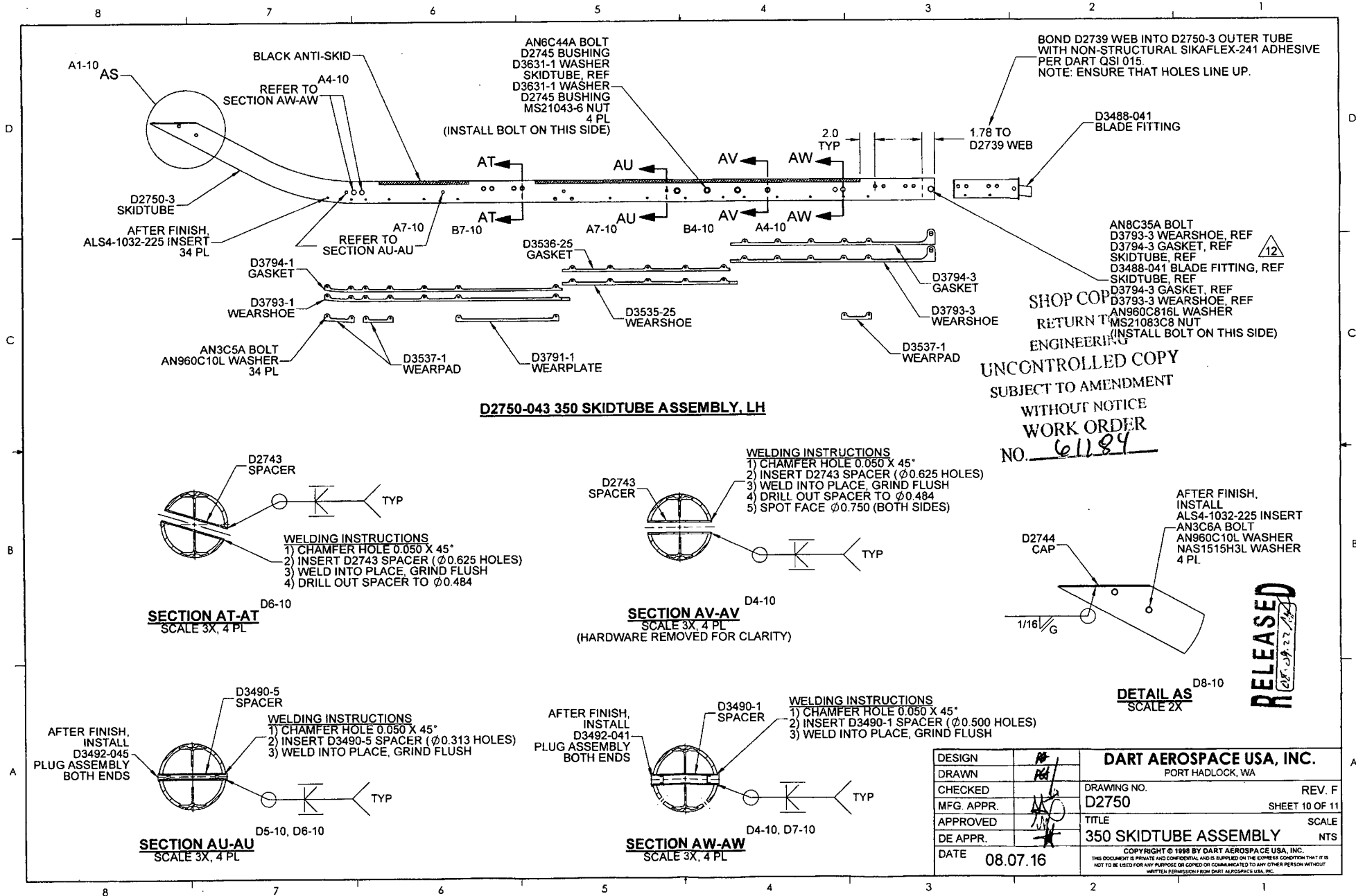
AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-041 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL BOLT ON THIS SIDE)

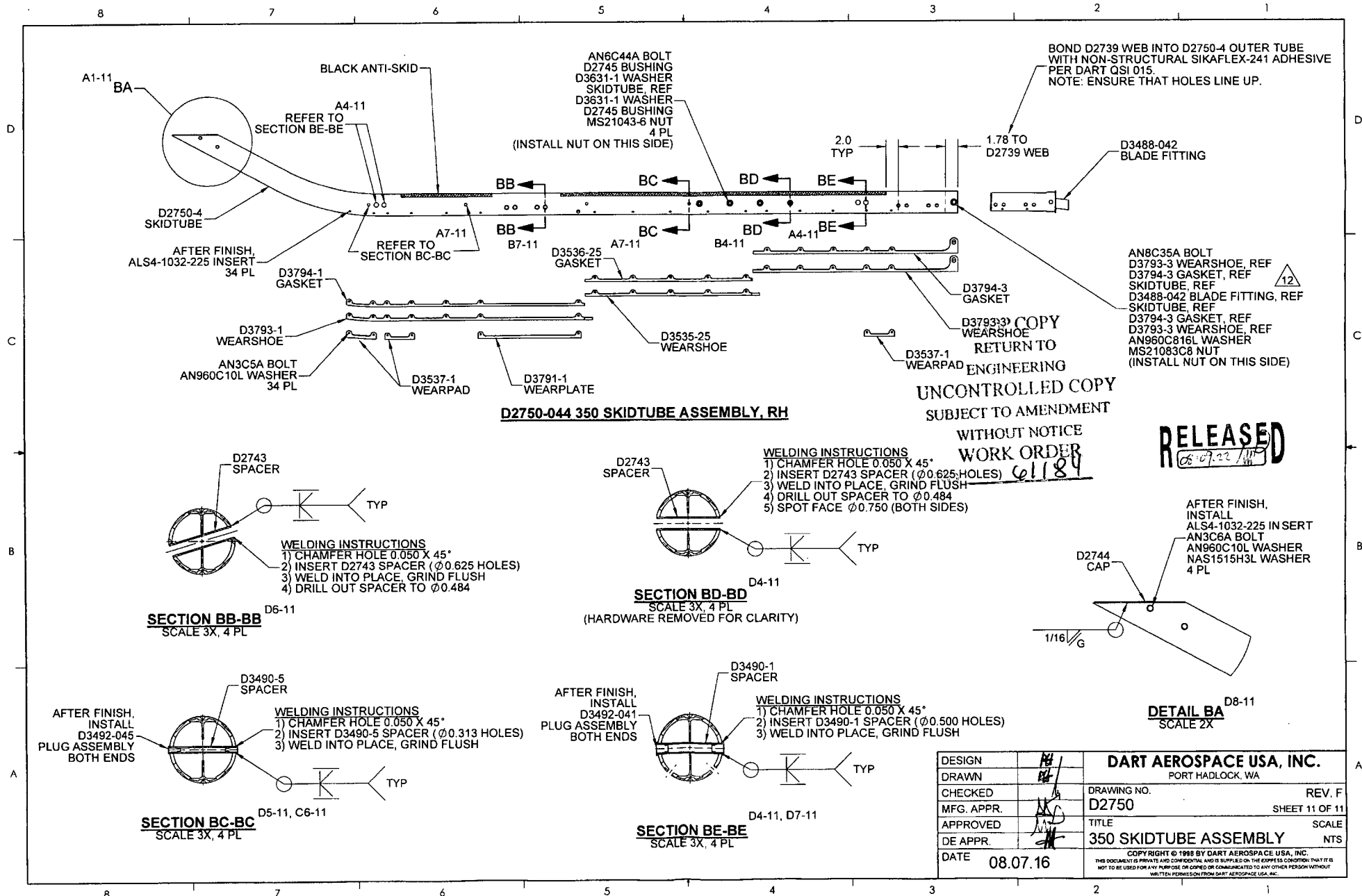


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NO. 236

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job number: 60988  
Part number: D350-136-012  
Description: 350 skid tube  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Aluminium  
Current: AC[ ☒ ] DC[ ☐ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[ ☒ ] fail[ ☐ ]  
Penetration: pass[ ☒ ] fail[ ☐ ]

UNACCEPTABLE

Cracks: pass[ ☒ ] fail[ ☐ ]  
Undercut: pass[ ☒ ] fail[ ☐ ]  
Pin holes: pass[ ☒ ] fail[ ☐ ]  
Overlap (cold lap): pass[ ☒ ] fail[ ☐ ]  
Porosity (surface): pass[ ☒ ] fail[ ☐ ]  
Coloration: pass[ ☒ ] fail[ ☐ ]

Qualifier [Signature] Date of Test Coupon 10.08.12

Welder [Signature] Date of Test Coupon 10.08.12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld